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D3650-1  
Job Sheet 184882



Part No: D3650-1

Part Name: Aft Panel

Job Qty: 5 ea

DAS  
21  
9-89



Part Weight: 0 lbs

Job Created: 10/17/18

Due Date: 10/31/18

Type: Stock

Status: New

Job Tracking No:

Created By: Shannon Hadley

Description:

Priority: Medium

Note: DWG REV E IPP Rev:A New Issue 07-09-27 DD verified by: EC IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off       |
|-------|-----------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------|
|       |           |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                |
| 100   | Waterjet  | 5 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.83    | Waterjet 1            |           | 12/10/17       |
| 110   | QC        | 5 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.00    | QC2 Waterjet-2        |           | 12/18/18 DAS   |
| 120   | QC        | 5 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.00    | QC8-3                 |           | OCT 18 2018 68 |
| 130   | Brake NC  | 5 pcs | 10/31/18   | 10/31/18 | 0.00      | 2.12    | Brake NC 2            |           | OCT 18 2018 68 |
| 140   | QC        | 5 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.00    | QC5                   |           | OCT 18 2018 68 |
| 150   | Small Fab | 5 pcs | 10/31/18   | 10/31/18 | 0.00      | 1.41    | Small Fab-4           |           | OCT 18 2018 68 |
| 160   | QC        | 5 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.00    | QC5                   |           | OCT 18 2018 68 |
| 170   | Packaging | 5 pcs | 10/31/18   | 10/31/18 | 0.00      | 0.00    | Packaging3-1          |           | OCT 18 2018 68 |
| 180   | QC21-SA   | 5 Ea  | 10/31/18   | 10/31/18 | 0.00      | 0.00    | QC21                  |           | OCT 22 2018 21 |

Part Op 100 - 1-Cut as per Dwg D3650 Dwg Rev: E Prog Rev: E 2-Deburr if necessary  
Descriptions: 130 - Form as per Dwg D3650  
150 - Assemble as per dwg D3650

### Job BOM

| Part / Item | Component Name      | Quantity             | Operation    | Container   |
|-------------|---------------------|----------------------|--------------|-------------|
| M304S26GA   | 304/316 0.018 Sheet | 7.9150 sf (1.583 ea) | 100-Waterjet |             |
| MS20427M3-3 | Rivet 6A008         | 90 Ea (18 ea)        | 100-Waterjet | fm 134738   |
| MS21060-3K  | Nut Plate ST300     | 30 Ea (6 ea)         | 100-Waterjet | fm 130256/1 |
| MS21062-3K  | Nut Plate ST300     | 15 Ea (3 ea)         | 100-Waterjet | fm 130329   |

### Job Allocations

| Operation    | Component Part | Required | Inventory | Allocated |
|--------------|----------------|----------|-----------|-----------|
| 100-Waterjet | M304S26GA      | 8        | 40        | 0         |
|              | MS20427M3-3    | 90       | 409       | 0         |
|              | MS21060-3K     | 30       | 5         | 0         |
|              | MS21062-3K     | 15       | 0         | 0         |

### Part Specifications

Specifications could not be found.

Plex 10/17/18 1:02 PM Dart.Hadley.Shannon

OLD 184678

P.T.O.

DQA:

Date:

QA Closed: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

19 July 2019



Work Order update only

|                                                                                                                                                                                                          |  |                        |  |                                                                                                                                                                                                                                   |  |                                                          |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                                                         |  |  |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                             |  |  |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------------------------|--|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|
| Work Order: 184882                                                                                                                                                                                       |  | DISPOSITION            |  | AGAINST DEPARTMENT/PROCESS                                                                                                                                                                                                        |  |                                                          |  | Engineering Quality Other                                                                                                                                                         |  |  |  |                                                                                                                                                                                                                         |  |  |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                             |  |  |  |
| Part No. D3650-1                                                                                                                                                                                         |  | Rework Scrap Use-as-is |  | Cross tube Small Fab Finishing Composite                                                                                                                                                                                          |  | Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                                                         |  |  |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                             |  |  |  |
| NCR No. 19-7337                                                                                                                                                                                          |  | Suspected Unapproved   |  | Skid-tube Machining Thermoforming Large Fab                                                                                                                                                                                       |  |                                                          |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                                                         |  |  |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                             |  |  |  |
| Date: 18-10-19                                                                                                                                                                                           |  | Step #: 100            |  | QTY Effective: 1                                                                                                                                                                                                                  |  |                                                          |  | MRB (QSI042) Approval                                                                                                                                                             |  |  |  |                                                                                                                                                                                                                         |  |  |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                             |  |  |  |
| Description Work Order Deviation                                                                                                                                                                         |  |                        |  | Disposition                                                                                                                                                                                                                       |  |                                                          |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                                                         |  |  |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                             |  |  |  |
| Damage found on material.                                                                                                                                                                                |  |                        |  | Scrap no replace<br>Damage part will be used as a template in small fab.                                                                                                                                                          |  |                                                          |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                                                         |  |  |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                             |  |  |  |
| Root Cause                                                                                                                                                                                               |  |                        |  | FAULT CATEGORY                                                                                                                                                                                                                    |  |                                                          |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                                                         |  |  |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                             |  |  |  |
| <div>Environment<br/>Design<br/>Doc/Data<br/>Equip/Tooling<br/>Handling/Pre<br/>Material<br/>Internal Transport<br/>Tribal Knowledge<br/>LOA<br/>Substation<br/>Past Expiry Date<br/>Misidentified</div> |  |                        |  | <div>No Re-verification<br/>Operator<br/>Offset/Setup<br/>Supplier<br/>Training<br/>Use for Testing<br/>Poor Information<br/>Rushing<br/>Product Improvement<br/>Process Improvement<br/>Manufacturing Process<br/>Past Due</div> |  |                                                          |  | <div>Pressure/Forced Bending<br/>Centre Not Concentric<br/>Cracks<br/>Crimp/Kink/Ripple/Wave<br/>Cuffs<br/>Crushing<br/>Heat Treat<br/>Wave/Twist in Tube<br/>Marks/Chatter</div> |  |  |  | <div>Temperature/Cure Set-up<br/>BOM/Route<br/>Broken/Damage/Defect<br/>Inspection Incomplete/Unqualified<br/>Contamination<br/>Countersink<br/>Cut Too Short<br/>Instructions Incomplete/Unclear<br/>Drill Holes</div> |  |  |  | <div>Power Loss/Surge<br/>Folio/Program<br/>Grain<br/>Weld<br/>Wrong Stock Pulled<br/>Out of Sequence<br/>Off-set<br/>Mislabeled<br/>Fit/Function<br/>Misaligned/off center</div> |  |  |  | <div>Positioned Wrong<br/>Outside Dimensions<br/>Over/Under tolerance<br/>Part Incorrect<br/>Part Lost/Missing<br/>Part Moved<br/>Drawing<br/>Finish<br/>Misread<br/>Turning Sequence</div> |  |  |  |
| OTHER :                                                                                                                                                                                                  |  |                        |  |                                                                                                                                                                                                                                   |  |                                                          |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                                                         |  |  |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                             |  |  |  |
| QC / QA Coordinator Approval                                                                                                                                                                             |  |                        |  |                                                                                                                                                                                                                                   |  |                                                          |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                                                         |  |  |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                             |  |  |  |
| DAS 9 18-10-19                                                                                                                                                                                           |  |                        |  |                                                                                                                                                                                                                                   |  |                                                          |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                                                         |  |  |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                             |  |  |  |
| Lead hand / Supervisor Approval Verification                                                                                                                                                             |  |                        |  |                                                                                                                                                                                                                                   |  |                                                          |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                                                         |  |  |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                             |  |  |  |
| DAS 9 19/07/19                                                                                                                                                                                           |  |                        |  |                                                                                                                                                                                                                                   |  |                                                          |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                                                         |  |  |  |                                                                                                                                                                                   |  |  |  |                                                                                                                                                                                             |  |  |  |

|                        |        |              |         |
|------------------------|--------|--------------|---------|
| DART AEROSPACE LTD     |        | Work Order:  |         |
| Description: Aft Panel |        | Part Number: | D3650-1 |
| Inspection Dwg: D3650  | Rev: E | Page 1 of 1  |         |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098            | +0.004/-0.001 | Ø.097            | 1      |        |                      |          |
| Ø0.213            | +0.005/-0.001 | Ø.212            | 1      |        |                      |          |
| Ø0.250            | +0.005/-0.001 | Ø.249            | 1      |        |                      |          |
| 0.25              | +/-0.030      | .25              | 1      |        |                      |          |
| 0.344             | +/-0.010      | .346             | 1      |        |                      |          |
| 0.35              | +/-0.030      | .35              | 1      |        |                      |          |
| 0.312             | +/-0.010      | .315             | 1      |        |                      |          |
| 16.611            | +/-0.010      | 16.611           | 1      |        |                      |          |
| 15.800            | +/-0.010      | 15.800           | 1      |        |                      |          |
| 3.950             | +/-0.010      | 3.949            | 1      |        |                      |          |
| 2.019             | +/-0.010      | 2.021            | 1      |        |                      |          |
| 4.026             | +/-0.010      | 4.027            | 1      |        |                      |          |
| 6.126             | +/-0.010      | 6.124            | 1      |        |                      |          |
| 8.226             | +/-0.010      | 8.224            | 1      |        |                      |          |
| 10.313            | +/-0.010      | 10.316           | 1      |        |                      |          |
| 12.252            | +/-0.010      | 12.252           | 1      |        |                      |          |
| 17.583            | +/-0.010      | 17.583           | 1      |        |                      |          |
| 16.646            | +/-0.010      | 16.646           | 1      |        |                      |          |
| 2.256             | +/-0.010      | 2.259            | 1      |        |                      |          |
| 7.183             | +/-0.010      | 7.184            | 1      |        |                      |          |
| 9.551             | +/-0.010      | 9.552            | 1      |        |                      |          |
| 10.665            | +/-0.010      | 10.668           | 1      |        |                      |          |
| 12.020            | +/-0.010      | 12.020           | 1      |        |                      |          |
| 0.018             | +/-0.010      | .019             | 1      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|              |                                                                                     |             |             |                       |  |
|--------------|-------------------------------------------------------------------------------------|-------------|-------------|-----------------------|--|
| Measured by: |  | Audited by: | DAS<br>68   | Preliminary Approval: |  |
| Date:        | 18/10/2017                                                                          | Date:       | OCT 19 2018 | Date:                 |  |

| Rev | Date     | Change                           | Revised by | Approved                                                                              |
|-----|----------|----------------------------------|------------|---------------------------------------------------------------------------------------|
| A   | 08.07.24 | New Issue                        | KJ/DD      |                                                                                       |
| B   | 09.06.15 | Dimensions updated per Dwg Rev C | KJ         |                                                                                       |
| C   | 12.09.26 | Dimensions updated per Dwg Rev D | KJ         |                                                                                       |
| D   | 14.09.18 | Dwg Rev updated                  | KJ         |  |